

ABSTRACT:

The invention relates to a method of rolling a strip-shaped in-process stock, in particular a metal strip, with which, a metal strip (3) is unwound from a coil (2, 7) held on an unwinding reel (1, 6), is fed into a reversing rolling mill (8), is rolled, and is wound-up onto a winding-up reel (9) to form a coil (10), wherein the metal strip (3) is reversibly conveyed from the unwinding reel (1, 6) to the winding-up reel (9) until a set thickness is reached and, with each passing of the reversing rolling mill (8), is subjected to a reduction of thickness, and wherein an end of the metal strip (3) of a first coil is welded to a beginning of the metal strip (3) of the second coil, and the metal strip (3) of the first coil is temporarily stored in a strip store during a welding process, and finally, the in-process stock consisting of two lengths is reversibly rolled to a final dimension, and an additional length is welded to the end of the in-process stock before the last pass.

The invention also relates to an installation for effecting the method and in which the unwinding reel (1, 6) is used as a strip store for the reverse pass.

Fig. 1